

Work Order ID 65293

January 11, 2011 9:16:56 AM



Page 1

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Item Name: Float Web (206L/407)

Stop



Start Date: 1/11/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *MR*

Date: 11-01-11 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3282 | Rev C |

100



Skidtubes

Skidtubes

Memo

0.00

0.00

4

11/01/12

- 1-Cut to length as per Dwg D3282.
- 2-inspect for surface damage as per QSI0018
- 3-Deburr

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

MR 11/01/13

4 *✓*

0.00

- 1-Machine as per Folio FA579 & Dwg D3282
- 2-Deburr

120



QC2- Inspect parts off machine FAI/FAIB

0.00

MR 11/01/18

4 *✓*

0.00

Memo

QC

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65293

January 11, 2011 9:16:57 AM



Page 2

Item ID: D3282-041

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Item Name: Float Web (206L/407)

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Start Date: 1/11/11 Start Qty: 4.00



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Required Date: 1/21/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 65293

January 11, 2011 9:16:58 AM



Page 3

Item ID: D3282-041

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Setup Start



Revision ID:

Item Name: Float Web (206L/407)

Stop



Start Date: 1/11/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Skidtubes

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Skidtubes

Memo

0.00

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3M110551

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location

0.00

Memo

0.00

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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Page 4

January 11, 2011 9:16:58 AM

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Item Name: Float Web (206L/407)

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Start Date: 1/11/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 4.00



Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

190



QC

QC21- Final Inspection - Work Order Release

Quality Control



Memos



0.00



0.00



0.00



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NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:16:56 AM

Page 1

Work Order ID: 65293



Parent Item: D3282-041



Parent Item Name: Float Web (206L/407)

Start Date: 1/11/11

Required Date: 1/21/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B □ 05.09.23 □ Procedure change □ KJ/JLM □

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MS20470AD4-7



Purchased

No

100

Each

2,292.000

57

228

Rivet, Universal Head

SAD 11-01-20

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST320 | 2292 | |
| 115996 | 992 | |
| 116081 | 1300 | |

D2792-130



Manufactured

No

160

Each

48.0000

1

4

EXTRUSION

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT06 | 48 | |
| 61630 | 48 | |

D3283-1



Manufactured

No

160

Each

33.0000

2

8

Doubler

BB 11-01-12

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST046 | 31 | |
| 62966 | 15 | |
| 63572 | 16 | |
| ST048 | 2 | |
| 57725 | 2 | |

3

5

11-01-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

DART

DESIGN CP DRAWN BY CP DART AEROSPACE USA, INC.

CHECKED APPROVED DRAWING NO. D3282

REV. C SHEET 1 OF 2

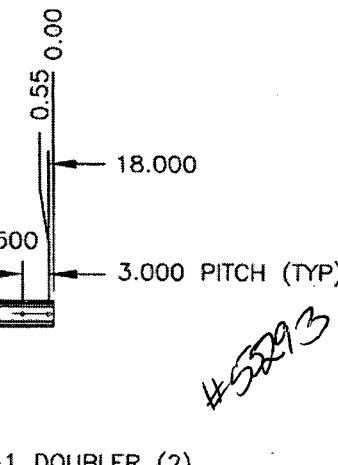
DATE 05.08.09 TITLE FLOAT WEB, 206L/407

SCALE 1:20

A 04.05.05 NEW ISSUE

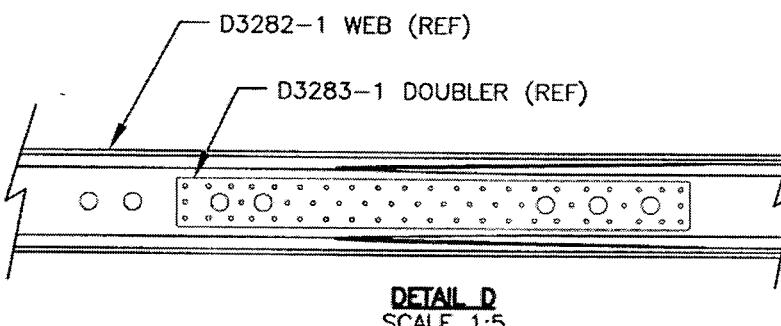
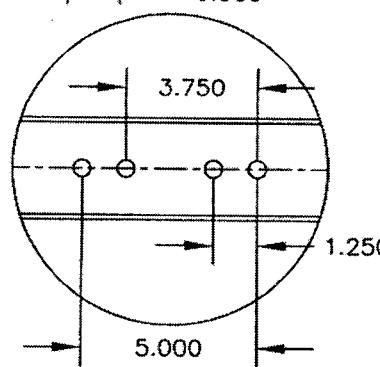
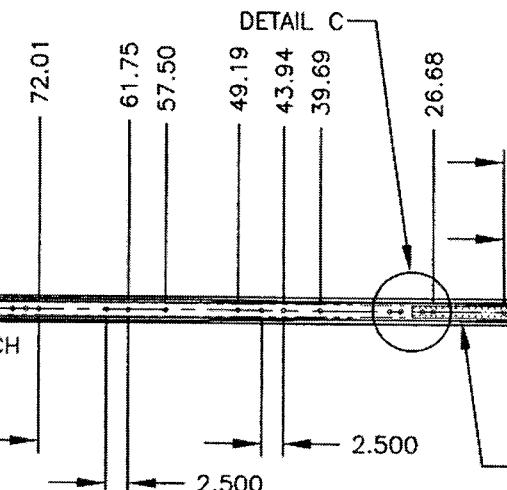
B 05.03.16 MOVE HOLES, ADD D3390-1 DOUBLERS

C 05.08.09 REMOVE D3390-1, NOW MACHINED



#5293
D3283-1 DOUBLER (2)
MS20470AD4-7 RIVET (57)
INSTALL WITH LPS-3,
SEE DETAIL D

RELEASED
05-09-12



D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

| W/O: | | WORK ORDER CHANGES | | | | | |
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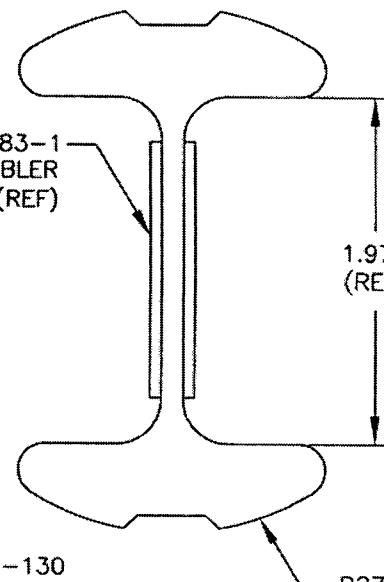
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NOTE: Date & initial all entries

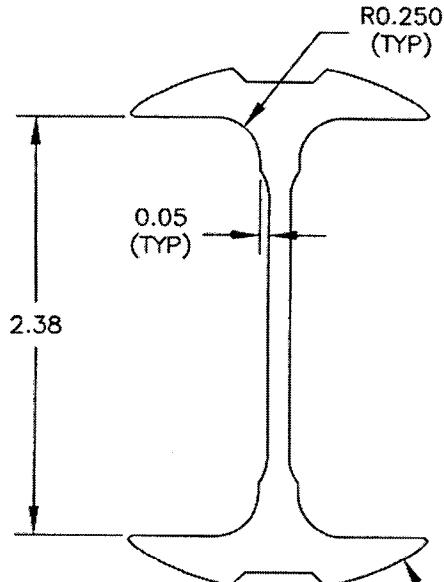
DART

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|---------|-------------------------------------|--------------|--------------------------|
| DESIGN | CP | DRAWN BY | DART AEROSPACE USA, INC. |
| CHECKED | <input checked="" type="checkbox"/> | APPROVED | DRAWING NO. D3282 |
| DATE | 05.08.09 | TITLE | FLOAT WEB, 206L/407 |
| REV. C | | SHEET 2 OF 2 | SCALE 1:20 |

SECTION B-B



SECTION A-A



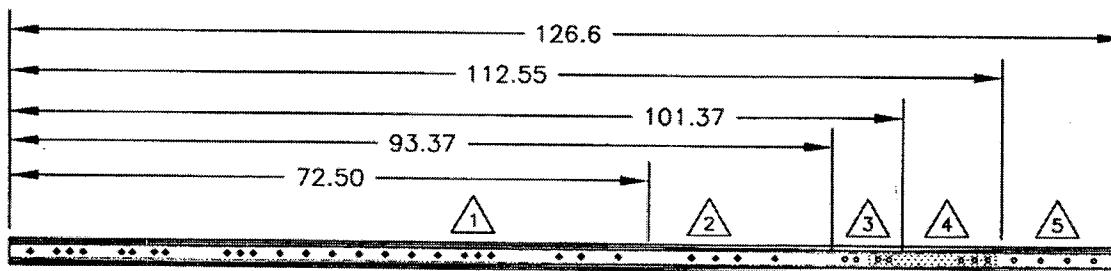
R0.250
(TYP)

0.05
(TYP)

2.38

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
05-09-12

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NOTE: Date & initial all entries

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|--|-------------------------------|
| DART AEROSPACE LTD | Work Order: |
| Description: Float Web | Part Number: D3282-041 |
| Inspection Dwg: D3282 Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|--------------|-------------|-----------|---------------------|-----|
| Measured by: | <u>Amber</u> | Audited by: | <u>SL</u> | Prototype Approval: | N/A |
| Date: | 11/01/18 | Date: | 11/01/19 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 07.04.02 | New Issue | KJ/JLM | <i>[Signature]</i> |